

44

20-88

DART AEROSPACE LTD	Work Order:	19534
Description: Long Step Assembly – High Skid, RH D350-591-212	Part Number:	704A 41 640 007
Dwg: D3070 Rev. A1 RF 02.11.13	Qty:	105
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg not required	HD	03.08.27	10
2	DC	Photocopy bluefile and type labels per PPP 704A 41 640 007 CHG001 CHG 001 WK 42	HD	03.10.07	10
3	GA	Cut D2622-120C extrusion to 116.25" long as per Dwg D3070 using cutting table setup DT8185-2A Pick: Qty Part Number Description Batch 1 D2622-120C Extrusion B18809 ml 04-02-02 5 Ensure wall thickness is 0.070 to 0.090			
4	GA	Drill extrusion per Dwg D3070 using Jig DT8680 for rivets.	ml	04-02-02	5
5	GA	Deburr	ml	04-02-02	5
6	QC5	Inspect work to Step 5	BS	04-02-02	5
7	WA	Bevel end for welding FWD ONLY	MA	04/02/06	5
8	WA	Weld Support using Jig DT8681, weld Fwd End Plate per QSI 004 & Dwg D3070 Pick: Qty Part Number Description Batch 1 D3063-1 Support B19555 MA 04/02/06 5 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066			
9	GA	Grind End Plate flush	MA	04/02/06	5
10	QC9	Inspect weld and work to Step 9	BS	04-02-11	5
11	FP	Chemical conversion coat as per QSI 005 4.1	2	04-02-13	5
12	GA	Assemble Leg Assembly as per Dwg D3070. D3066-1 are done Pick: with Step Long Assy, don't add to the sum. RF 03.11.13 Qty Part Number Description Batch 1 D3065-041 Step Leg Assy 019557 2 D3066-1 Spacer 019557 16 MS20600AD4W4 Rivet M13767	BS	02/04/18	5
13	QC5	Inspect work to step 12	MA	04/02/06	5
14	WA	Bevel Aft end for welding	MA	04/02/06	5
15	WA	Inspect for foreign object per QSI 024	MA	04/02/06	5
16	WA	Weld Aft End Plate per QSI 004 & Dwg D3070 Pick: Qty Part Number Description Batch 1 D3067-1 End Plate B19558 A/R Aluminum Rod M13066	DA	04/02/06	5

BB 04-02-25/08

CANCELLED 03.11.16
UNDER REVIEW
03-06-06 RF
See Draft

RELEASED
02/11/01 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	19534
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Dwg: D3070 Rev. A 1	Qty:	105
		Page 2 of 2

17	GA	Grind End Plate flush	SB	04/02/19	5
18	QC9 & 5	Inspect work to Step 17 – Check dimension 110.56" from Dwg D3070 110.71" RF 02.11.13	6	04-02-20	5
19	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per QSI 005 4.3	2	04-02-23	5
20	FP	Wing Walk per Dwg D3070 and QSI 005 4.4	31	04-02-23	5
21	QC3	Inspect Powder Coat and Wing Walk	10	04-02-24	5
22	KP	<u>Pick: Packing Kit</u> <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 4✓ D2182B035 Rubber Cushion B19540 8✓ D2274 Radius Block B20207 2✓ D2856-400-720 Abrasion Strip B18972 2✓ D3064-1 Clamp B20123 1✓ D3070-041 04.02.21 Support Assy B200510 4✓ D3080-1 Clamp B19559 2✓ AN3-35A Bolt M12963/ M13943 10✓ AN4-11A Bolt M13735 4✓ AN960JD10 Washer M13719 20✓ AN960JD416 Washer M13719 2✓ MS21042L3✓ Nut (or -3) M14019 10✓ MS21042L4✓ Nut (or -4) M113276	Ch.	04.02.24	5
23	QC4	Inspect 100% Kit for Completeness on the W/O	10	04-02-24	5
24	PK	Package for shipping as per PPP 704A 41 640 007	10	04-02-24	5.
25	AC	Cost / part 243.62	545	04.02.25	5
26	DC	Close W/O 243.62 Inspect Level 21	10	04.02.26	5

Rev	Date	Change	Revised By	Approved
A	02.11.01	New issue	KJ RF	✓
A1	03.01.14	110.71" WAS 110.56" ; Dwg. Rev. A1	RF	✓
A2	03.07.16	D3194-041 WAS D3070-041 ; CHG002	RF	✓

UNDER REVIEW

03-09-06 RF

See Drawing
CANCEL RF 05.01.16

RELEASED
02/11/02

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
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QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
HawkesburyAug 27, 2003
02:05 pm

Work Order No : 0019534
 Project Name : *704A 41 640 007
 Project For : wk344
 Work Order Type : Main
 Main WO Number :
 House Part Number : *704A 41 640 007
 Description : Heli-Access-Step, Long RH
 Manufactured : Yes
 Amount Req'd : *105*
 Amount Done : 0
 Start Date : 08-27-03
 Est Finish Date : 11-06-03
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :
 Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Margin : 0.000%
 Actual Margin : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00	0.00	
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00